



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-633-024
Job Sheet 174229



Part No: D205-633-024

Job Qty: 1

Part Name: Heli-Access-Step™ RH - 31" Extended Height Gear, Simplex Tank Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/13/18

Job Tracking No:

Due Date: 4/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 17 IPP Rev:A new issue Rev B dwg 07-11-19 DD verified by:EC lpp RevB 11.07.26 per NCR 11-628 EC verified by:JLM IPP Rev:C 11.09.12 remove D3165-1 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	4/5/18	4/5/18	0.00	0.00	Start Up Stores/Pkg-1		MAR 29 2018
110	Packaging	2 pcs	4/5/18	4/5/18	0.00	0.00	Packaging1-2		MAR 29 2018
120	QC	2 pcs	4/5/18	4/5/18	0.00	0.00	QC4		SmB
125	DC	2 pcs	4/5/18	4/5/18	0.00	0.00	DC		SmB
130	Packaging	2 pcs	4/5/18	4/5/18	0.00	0.00	Packaging3-1		SmB
140	QC21-FG	2 Ea	4/5/18	4/5/18	0.00	0.00	QC21		APR 1 2018

Part Op 125 - Photocopy bluefile & type labels per PPP D205-633-024 CHG001

Descriptions: 130 - Identify and pack for shipping as per PPP D205-633-024

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-12A	Bolt	2 Ea (1 ea)	90-Start up Operation	5014151
AN4-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5027723
AN4-5A	Bolt	2 Ea (1 ea)	90-Start up Operation	5027725
AN4-6A	Bolt	6 Ea (3 ea)	90-Start up Operation	5044186
AN4-7A	Bolt	2 Ea (1 ea)	90-Start up Operation	PM134820.80
AN44-7A	Eyebolt	2 Ea (1 ea)	90-Start up Operation	5045071 x 4
AN5-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5045077 x 2
D2022-101	Spacer	8 Ea (4 ea)	90-Start up Operation	5053719
D2022-103	Spacer	4 Ea (2 ea)	90-Start up Operation	5009680
D2562-013	Strut 26.63"	2 Ea (1 ea)	90-Start up Operation	5009714
D2565-201	Strut	2 Ea (1 ea)	90-Start up Operation	5009804
D2565-203	Strut	2 Ea (1 ea)	90-Start up Operation	5009465
D2565-205	Strut	2 Ea (1 ea)	90-Start up Operation	5009482
D2565-207	Strut	2 Ea (1 ea)	90-Start up Operation	5008513
D2565-209	Strut	2 Ea (1 ea)	90-Start up Operation	5045071
D2565-211	Strut	2 Ea (1 ea)	90-Start up Operation	5045071
D3437-043	Aft Strut Assembly	2 Ea (1 ea)	90-Start up Operation	5045071
D3438-042	Weldment Assembly	2 Ea (1 ea)	90-Start up Operation	5045071
MS21042L4	Nut	14 Ea (7 ea)	90-Start up Operation	5045071
MS21042L5	Nut	4 Ea (2 ea)	90-Start up Operation	5016880
NAS1149D0463J	Washer	28 Ea (14 ea)	90-Start up Operation	5045845
NAS1149D0563J	Washer	6 Ea (3 ea)	90-Start up Operation	5025743

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																		
Description Work Order Deviation				Disposition																					
Root Cause <table style="width:100%; border: none;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="width:33%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>						Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐												
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		OTHER : ☐																							

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-12A	2	167	0
	AN4-14A	2	409	0
	AN4-5A	2	100	0
	AN4-6A	6	741	0
	AN4-7A	2	76	0
	AN44-7A	2	9	0
	AN5-14A	2	7	0
	D2022-101	8	69	0
	D2022-103	4	39	0
	D2562-013	2	0	0
	D2565-201	2	2	0
	D2565-203	2	2	0
	D2565-205	2	2	0
	D2565-207	2	3	0
	D2565-209	2	3	0
	D2565-211	2	2	0
	D3437-043	2	2	0
	D3438-042	2	2	0
	MS21042L4	14	1	0
	MS21042L5	4	3,343	0
	NAS1149D0463J	28	805	0
	NAS1149D0563J	6	4,436	0
			2,202	0

Part Specifications

could not be found.

*** Port laleunesse.marie

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CANADA
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www.dartaerospace.com



Container No: S056401

DART
AEROSPACE

Part: D205-633-024
Job No: 174229
Serial No/Batch: S056401
Revision:
Inspector:

Date: 03/29/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001982	S055399	AN4-12A	Bolt	S014151	ST344	1
001982	S055512	AN4-12A	Bolt	S055399	ST344	1
001982	S055390	AN4-14A	Bolt	S027723	ST344	1
001982	S055514	AN4-14A	Bolt	S055390	ST344	1
001982	S055383	AN4-5A	Bolt	S027725	ST345	1
001982	S055515	AN4-5A	Bolt	S055383	ST345	1
001982	S055380	AN4-6A	Bolt	S044186	ST345	3
001982	S055516	AN4-6A	Bolt	S055380	ST345	3
001982	S055378	AN4-7A	Bolt	FM137820.80	ST345	1
001982	S055517	AN4-7A	Bolt	S055378	ST345	1
001982	S055518	AN4-7A	Eyebolt	S054099	ST339	1
001982	S034849	D2022-101	Spacer	S034839	ST001	4
001982	S055285	D2022-103	Spacer	S045077	ST001	2
001982	S055523	D2022-103	Spacer	S055285	ST001	2
001982	S055873	D2562-013	Strut 26.63"	S053719	ST353	1
001982	S055216	MS21042L4	Nut	S045901	ST303	7
001982	S055524	MS21042L4	Nut	S055216	ST303	7
001982	S055215	MS21042L5	Nut	S016880	ST303	2
001982	S055525	MS21042L5	Nut	S055215	ST303	2
001982	S055171	NAS1149D0463J	Washer	S045845	ST263	14
001982	S055527	NAS1149D0463J	Washer	S055171	ST263	14
001982	S055170	NAS1149D0563J	Washer	S025743	ST263	3
001982	S055530	NAS1149D0563J	Washer	S055170	ST263	3

D3438-042

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

D2565-203 5009714 1X
D2565-207 5009465 1X
D2565-201 5009680 1X
AN5-14A 5056344 1X

~~D2565-203 5009714 1X~~
D3437-043 5011844 1X
~~D2562-013 5053719 1X~~
D2565-205 5009804 1X
D2022-101 5045071 4X
D2565-209 5009482 1X
D2565-211 5008513 1X

Plex 3/28/18 12:45 PM Dart.joly.jocelyne

5.2 D205-633-021/-022/-023/-024/-025/-026 Heli-Access Step
(Simplex Model 304 Fire Attack Tank Compatible)

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Heli-Access-Step™ (LH), High Gear
	X					D205-633-022	Heli-Access-Step™ (RH), High Gear
		X				D205-633-023	Heli-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Heli-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Heli-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Heli-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
				*1	*1	D3165-1	SUPPORT ARM
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

* ONLY INSTALLED IF TANK IS REMOVED

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Revision: C

Date: 13.12.13